

Date: Monday, 1/8/2007 7:57:36 AM  
User: Jean-Luc Menard

## Process Sheet

*split*  
*07/01/15*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 30204	
Estimate Number : 12631	
P.O. Number :	Part Number : D2127251905
This Issue : 1/8/2007 S.O. No. :	Drawing Number : D212-725-1 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material :
Written By : <i>JLM/07-01-09</i>	Due Date : 1/15/2007 Qty: 3 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-01-08 JLM	

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 M304TR1000WO49 304 RD Tube 1.0" x .049W



Comment: Qty.: 3.1500 f(s)/Unit Total : 9.4500 f(s)  
304 RD Seamless Tube 1.0" x .049W  
Batch: *M19448*

50"

FF 07-01-10

3

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-Form as per Dwg D212-725-1 & Template DT8907

FF 07-01-10

3

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*207-01-15 (3)*

4.0 MS2081916J Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Sleeve  
Batch: *M17123 (x5) / M103249*

FF 07-01-15

3

5.0 AN81816J Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Nut  
Batch: *M103177 (x5) / M1256 (x1)*

FF 07-01-15

3

Date: Monday, 1/8/2007 7:57:36 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 30204

Part Number: D2127251905

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Flare and Install Sleeves & Nut as per Dwg D212-725-1.

FF 07-01-10  
FF 07-01-15

2  
3

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/08 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/09 (2)

07/03/09

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

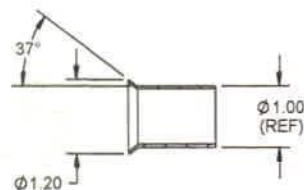
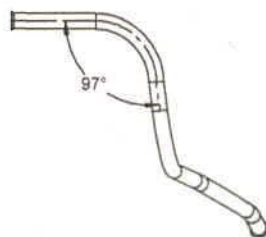
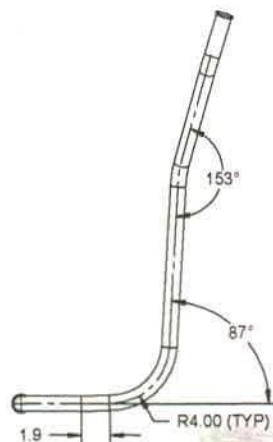
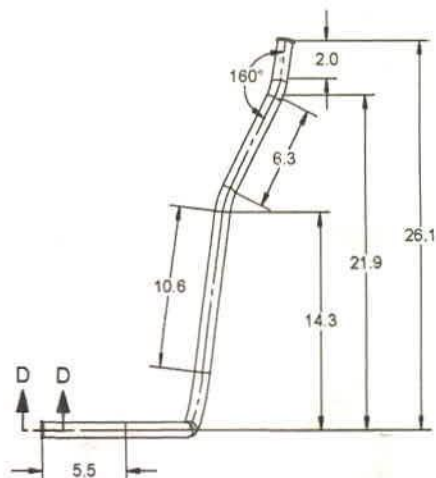
07/03/08 (2)

Job Completion



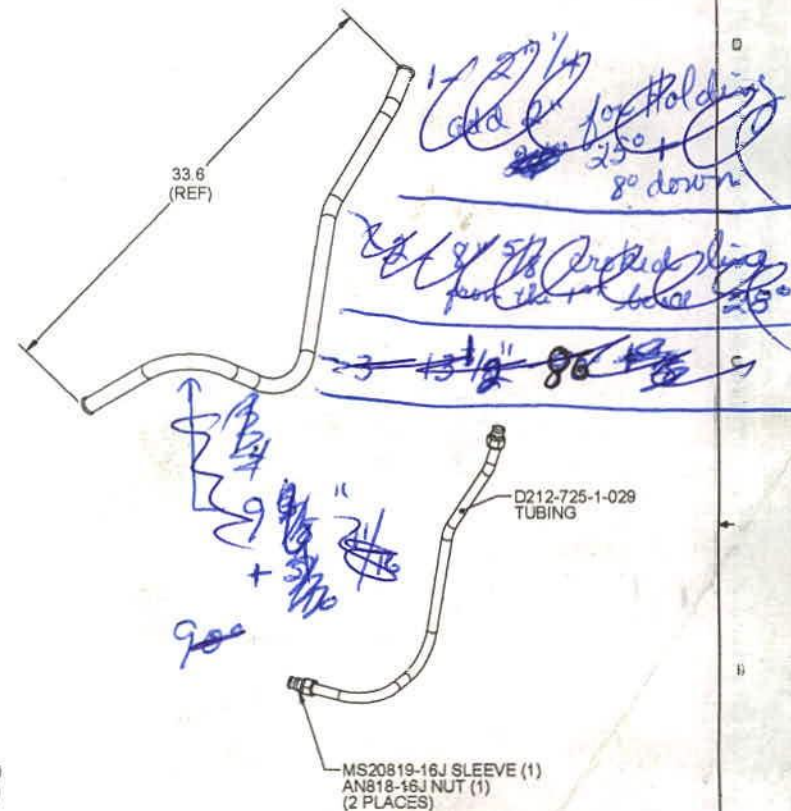
U 07-03-09





SECTION D-D  
(FINISH FLARE ONE END  
AFTER ASSEMBLY)  
SCALE 1:2  
(2 PLACES)

**D212-725-1-029 TUBING**  
MANUFACTURE PER TEMPLATE DT8907



**D212-725-1-905 TUBE ASSEMBLY**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL 1.00 O.D. x 0.049 WALL  
(REF. DART SPEC. M304TR1.000W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN DC	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A
DATE 06.12.08		TITLE 212S DETAIL PARTS	SHEET 10 OF 37 SCALE 1:1
COPYRIGHT © 2006 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/10	2	1 piece was scrapped. Material wrinkled in the bend radius.	J Q51042	Scrap & destroy & replace	FF 07/01/10	J 07-01-15	J Q51042	J 07-01-15

NOTE: Date & initial all entries